

Work Order ID 81766

March-19-12 7:44:11 AM

81766

Page 1

Item ID: DSK076

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: D2891-1 TURNING DETAIL

Start Date: 19/03/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 02/04/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/03/19

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

DSK076

Rev A

100

0.00

100

DOOSAN LATHE

24 12.3.25

Doosan

Memo

0.00

Doosan Lathe

Turn blank for as per Folio FA046

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

24 12.3.25

QC

Memo

0.00

Quality Control

120

0.00

120

QC8- Inspect parts - second check

B.A 12/03/26

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 81766

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Page 2

March-19-12 7:44:11 AM

Item ID: DSK076 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: D2891-1 TURNING DETAIL
 Start Date: 19/03/2012 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 02/04/2012 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and Stock in KanbanLocation: <u>CNC</u>								
140									
	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

24 2.3.25

MCS 12/03/24

12-03-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March-19-12 7:44:16 AM

Page 1
1

Work Order ID: 81766

81766

Parent Item: DSK076

DSK076

Parent Item Name: D2891-1 TURNING DETAIL

Start Date: 19/03/2012

Required Date: 02/04/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP rev A. 08.03.13 new issue EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D6104-003		Manufactured	No				Each	18.0000		10			
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D6104-003

Round Billet, 17-4

**
RF 12.3.24

Location	Loc Qty	Loc Code
MAT	10	
80932 ✓	10	
MAT043	7	
60943	3	
66960	1	
72807	3	
MAT047	1	
77628	1	

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	81766
Description: Turning Detail for D2891-1		Part Number:	DSK076
Inspection Dwg: DSK076		Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	2.274	2.279		2.278	2.278	2.278	2.278	2.278
B	3.702	3.722		3.712	3.712	3.712	3.712	3.712
C	2.564	2.584		2.576	2.576	2.576	2.576	2.576
D	0.718	0.738		.727	.727	.727	.727	.727
E	0.090	0.110		.100	.100	.100	.100	.100
F	2.464	2.484		2.474	2.474	2.474	2.474	2.474
G	2.029	2.049		2.039	2.039	2.039	2.039	2.039
H	2.964	2.984		2.975	2.975	2.975	2.975	2.975
I	0.913	0.933		.924	.924	.924	.924	.924
J	0.022	0.042		.032	.032	.032	.032	.032
K	0.090	0.110		.098	.098	.098	.098	.098
L								
M								
N								
O								
P								

Measured by:		Date:	
Audited by:	D.A.	Date:	12/03/26
Prototype Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	81766
Description: Turning Detail for D2891-1		Part Number:	DSK076
Inspection Dwg: DSK076	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

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I	0.913	0.933		.924	.924	.924	.924	.924
J	0.022	0.042		.032	.032	.032	.032	.032
K	0.090	0.110		.098	.098	.098	.098	.098
L								
M								
N								
O								
P								

Measured by: DP Date: 12-3-6

Audited by: BA Date: 12/03/26

Prototype Approval: _____ Date: _____

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	<u>[Signature]</u>

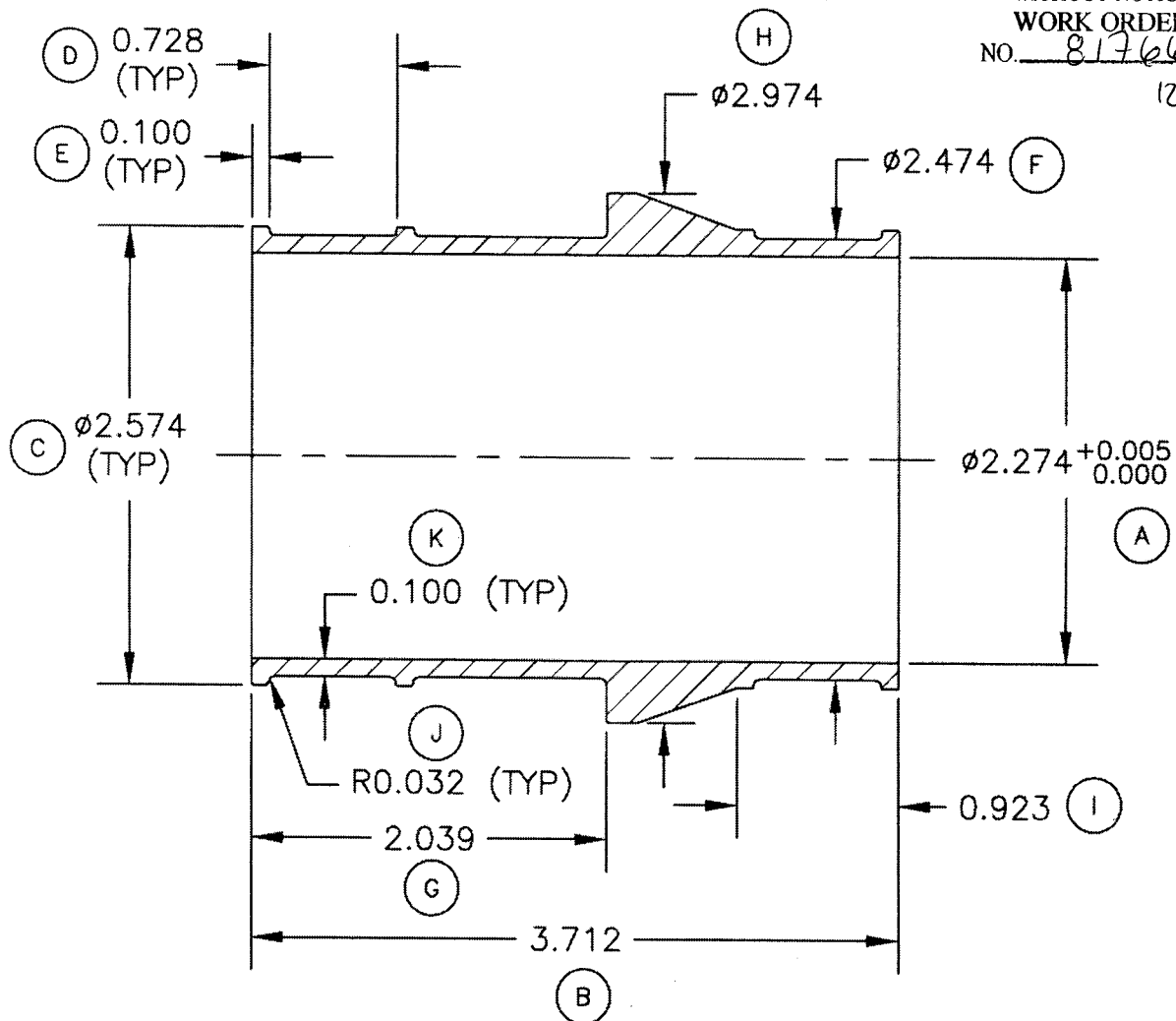


DESIGN H	DRAWN BY H	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. DSK 076	REV. A SHEET 1 OF 1
DATE 03.05.20		TITLE TURNING DETAIL FOR D2891-1	SCALE 1:1
A	03.05.20	NEW ISSUE	

RELEASED
03.07.01

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 81766 MLJ

12/03/19



D2891-1 TURNING DETAIL

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